

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: GAS SPRING ASSEMBLY	
Job Number	: 36845			
Estimate Number	: 10181			
P.O. Number	:	Part Number	: D2153	
This Issue	: 1/17/2008 S.O. No. :	Drawing Number	: D2153 REV. A1	
Prsht Rev.	: NC	Project Number	: N/A	
First Issue	: / / Type : PURCHASED PARTS	Drawing Revision	: A1	
Previous Run	: 29047	Material	:	
Written By	: _____	Due Date	: 1/31/2008	Qty: <u>36</u> Um: Each
Checked & Approved By	: _____			
Comment	: Est: E 02.07.08 Re-format KJ/RF			

Job Number:

Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O: 5987

Gas Spring P/N: SL13-10 (10lb)

Possible supplier: Spring Lift Corporation

****Note: Do not ship by air******

Allow an extra 7 to 10 business days for shipping**

Material release note is required

2.0	D2153P	Door Prop
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 20.0000 Each(s)
GAS SPRING ASSEMBLY

3.0 PACKAGING 1 PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1

Receive & Inspect for Transit Damage

Ensure Material Release Note is attached

4.0 QC6 DIMENSIONAL CHECK

Comment: DIMENSIONAL CHECK

Inspect Test Spring is 10lb

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 1/17/2008 3:31:38 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GAS SPRING ASSEMBLY

Job Number: 36845

Part Number: D2153

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D30153

Lock Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 40.0000 Each(s)

Lock Nut

Pick:

Qty Part Number

Description

Batch

2 D3015-3

Lock nut

35479

72

LO

6.0

AN960JD516

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 40.0000 Each(s)

Washer

Pick:

Qty Part Number

Description

Batch

2 AN960JD516

Washer

1106167

72

W

7.0

SL69BS

Ball Stud



Comment: Qty.: 2.0000 Each(s)/Unit Total : 40.0000 Each(s)

Ball Stud

Pick:

Qty Part Number

Description

Batch

2 SL69-BS

Stud

102458 64X M106939 8X

24.1/30

36

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Assemble as per Dwg D2153

2- Remove Spring Lift name and address with Acetone, leave only warning:

"DO NOT OPEN HIGH PRESSURE"

08/01/30 36

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/01/30 36

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST439

08/02/01 36

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: D Date: 02/02/04
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 1/17/2008 3:31:38 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GAS SPRING ASSEMBLY

Job Number: 36845

Part Number: D2153

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

QC21

FINAL INSPECTION/W/O RELEASE



(36)

Comment: FINAL INSPECTION/W/O RELEASE

2008/02/04

Job Completion



in 2008/2/04

(36)

W

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

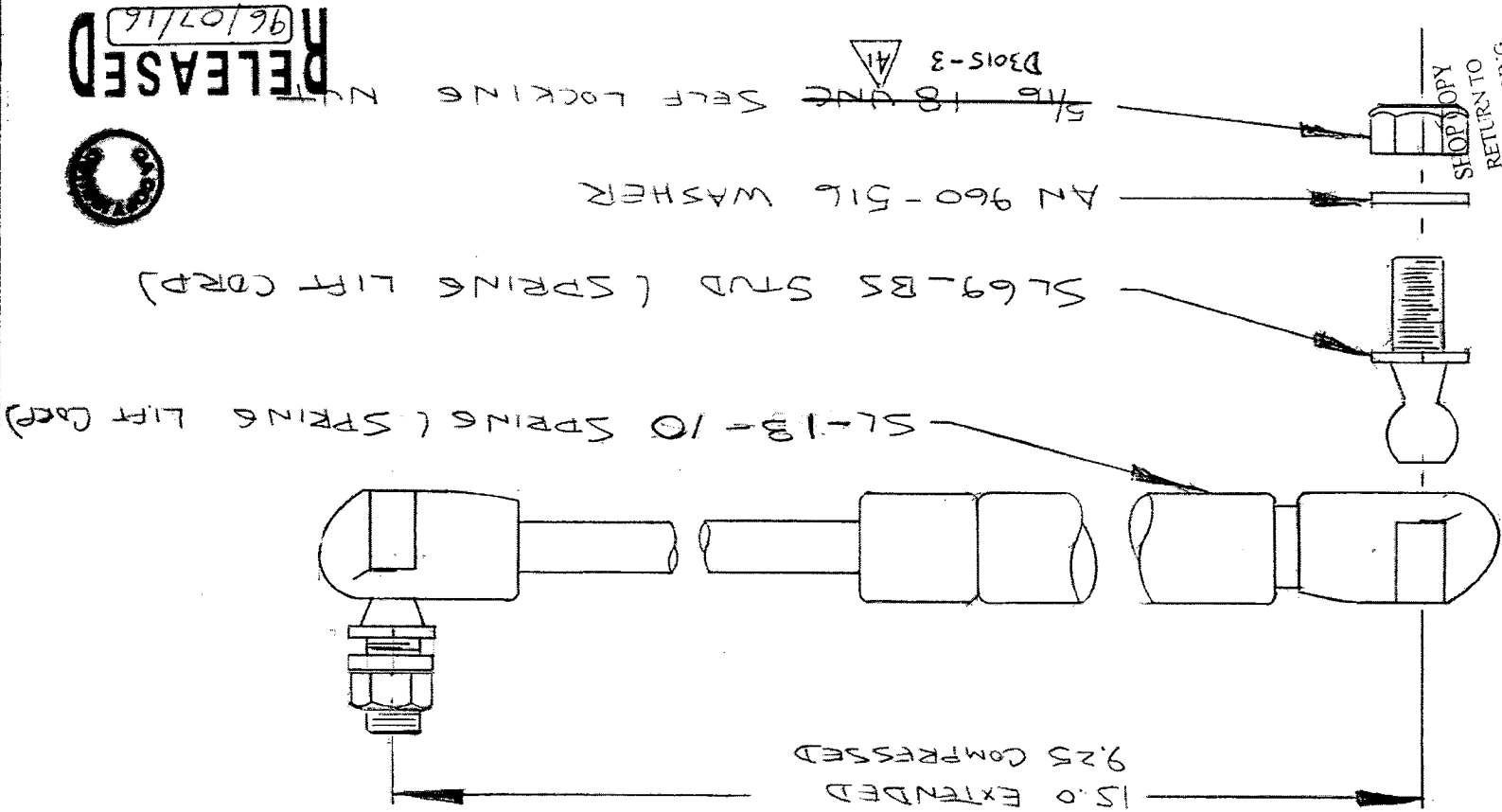
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

[illegible]

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
36845
NO.



RELEASED
96/07/16
CIVIL RIGHTS

D2153

attwood**SWIVL-EZE**

TELEPHONE: 616-897-2290

CUST: 68530 MST: 90173-00

BILL TO: DART AERO LTD.
REQ: 01/22/08

COLLECT 151793240

PRO NO: 778104318
SHIP VIA: FEDEX GROUND
BOL: 00226970000933232

F ATTWOOD / SWIVL-EZE

FREIGHT:

O 1016 NORTH MONROE

M LOWELL MI 49331-0260

T DART AERO LTD.
O 1270 ABERDEEN STREET

HAWKESSBURY ON K6A 1K7

CRTS: / X PO#: 5487

WGT: 15 DATE: 01/24/08

SPUR: 4

LABEL NO:
453370524

--ROUTING GUIDE INFO --

---SHIPPED---

CRTS	QTY	LOCATN	PART#	UPC	DESCRIPTION / SKU	LINE	QTY	WG
1	36	Z09211	EA	SL13-10-1	GS SPRNG 15" EXTC 10# BL	1	36	1
1	100	Z10321	EA	SL69-BE-1	10MM BALL STUD W/THRD	2	100	

===== COMPLETE ===== PICK BY: